

Date: Wednesday, 20/05/2009 2:49:28 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D212-725-1-007
Job Number	: 48087		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D2127251007
This Issue	: 20/05/2009 S.O. No. :	Drawing Number	: NCR09-062
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 27/05/2009 Qty: 5 Um: Each
Checked & Approved By	: <u>MF 09-05-20</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2127251007	COLLECTIVE BELL CRANK
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

COLLECTIVE BELL CRANK

Pull the items from stock for an LPI re-work.

B 42967 Qty 5

09-05-20

11

(x5)

2.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH
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Comment: Sub-Contracting OUTSIDE SERVICES-MACH

LPI per ASTM 1417 level 2 & as per drawing

P/O: 8893

C209/05/29 (5)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Inspect for transit damage

Ensure copy of NDT results attached to work order.

C209/05/29 (5)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S09/05/29 (x5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify the parts with the new batch #, and return items to stock.

S09/05/29 (x5)

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Drawing Name: D212-725-1-007

Job Number: 48087

Part Number: D2127251007

Job Number:



Seq. #:

Machine Or Operation:

Description :

Location: _____

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

20/05/09

Job Completion



MF 09-05-09



LIQUID PENETRANT TEST REPORT

P - 1417 1

CLIENT	DART AEROSPACE	DATE	MAY 29, 2009	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB NO.	188 09 1417	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST HAWKESBURY, ONT.	POWOW No.		WORK LOCATION	HAWKESBURY		
PROJECT	X TUBE AND COLLECTIVE BELL CRANKS	ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
ITEM(S) EXAMINED	JOB #S 47950, 48087						

JOB DESCRIPTION	PROCEDURE NO. LT-0002	REV./DATE	TECHNIQUE No. LT-TECH2	REV./DATE
PART No. D407667105/D2127251007	MATERIAL ALODINED ALUM.	THICKNESS		
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

TEST DETAILS					
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL MAY 23 09	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < - 4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS-	<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL
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FLUORESCENT LIQUID PENETRANT INSPECTION
CARRIED OUT ON 100% EXTERNAL
SURFACE ON:

407 FWD X TUBE JOB#S 47950
5 COLLECTIVE BELL CRANKS JOB# 48087

RESULTS: NO INDICATION OF DEFECTS.
ITEMS ACCEPTABLE TO STANDARD

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES	
CLIENT REPRESENTATIVE	DTR # E 27885
TECHNICIAN (SIGNATURE):	REPORT REVIEWED BY:
NAME (PRINT): JASON HEWETT	NAME INITIALS
1 ST TECHNICIAN	2 ND TECHNICIAN
CGSB LEVEL 2 SNT LEVEL	CGSB LEVEL SNT LEVEL
CGSB REG. No 6156	CGSB REG. No

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY